

94317

Friday, December 07, 2012 9:20:12 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

3

3

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-7-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

**Insp.
Stamp**

Revision Nbr

D3913

B

0.00

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D3913

Prog Rev: 3

Dwg Rev: B

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

Work Order ID 94317

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Page 2

Item ID: D3913-15 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wide Handle Plate
 Start Date: 12/7/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/13/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>WACU</u>	0:00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
16
12/12/10

12-12-10

DAS
09
12-12-10

12

12-12-11

12/12/11

12-12-11

Picklist Print

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Work Order ID: 94317

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Parent Item: D3913-15

D3913-15

Parent Item Name: Wide Handle Plate

Start Date: 12/7/2012

Required Date: 12/13/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

109.4500

0.1068

~~0.337263~~

M304S11GA

**



Jmr12-12-10

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

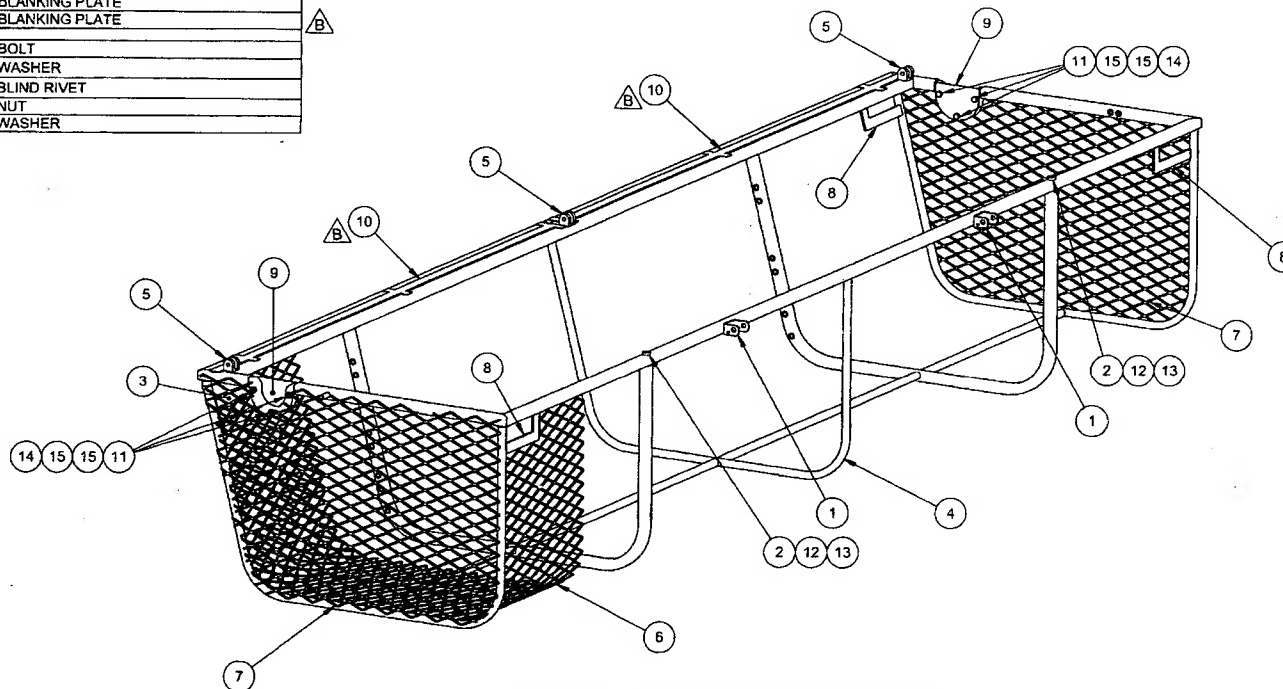
109.45



109.45

122521

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

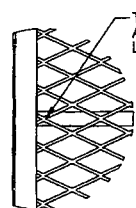
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

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2012-07-12
ECN 12-60

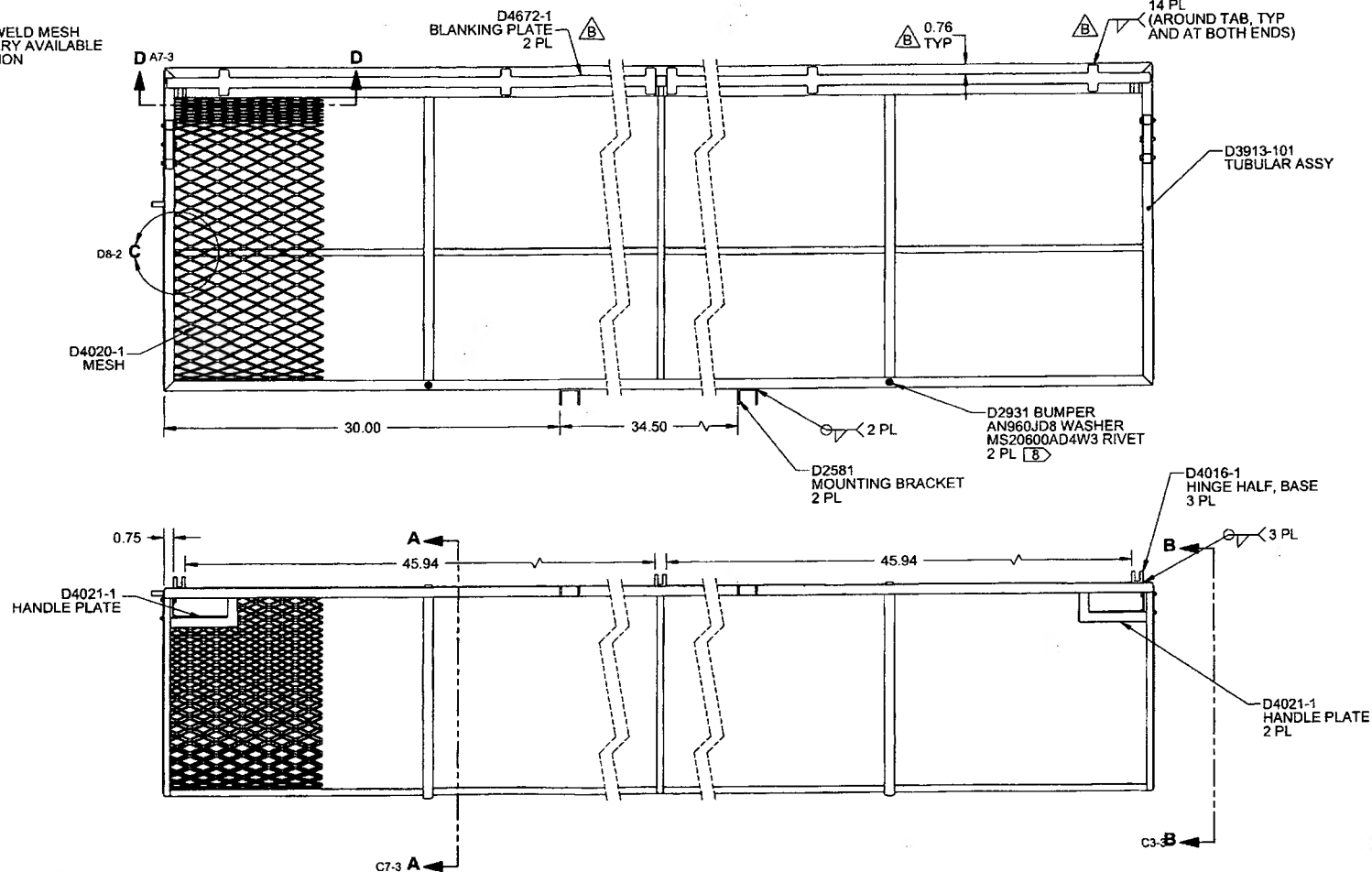
REV.	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
DESIGN	DESCRIPTION	BY	DATE
DRAWN	ADD		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. B
TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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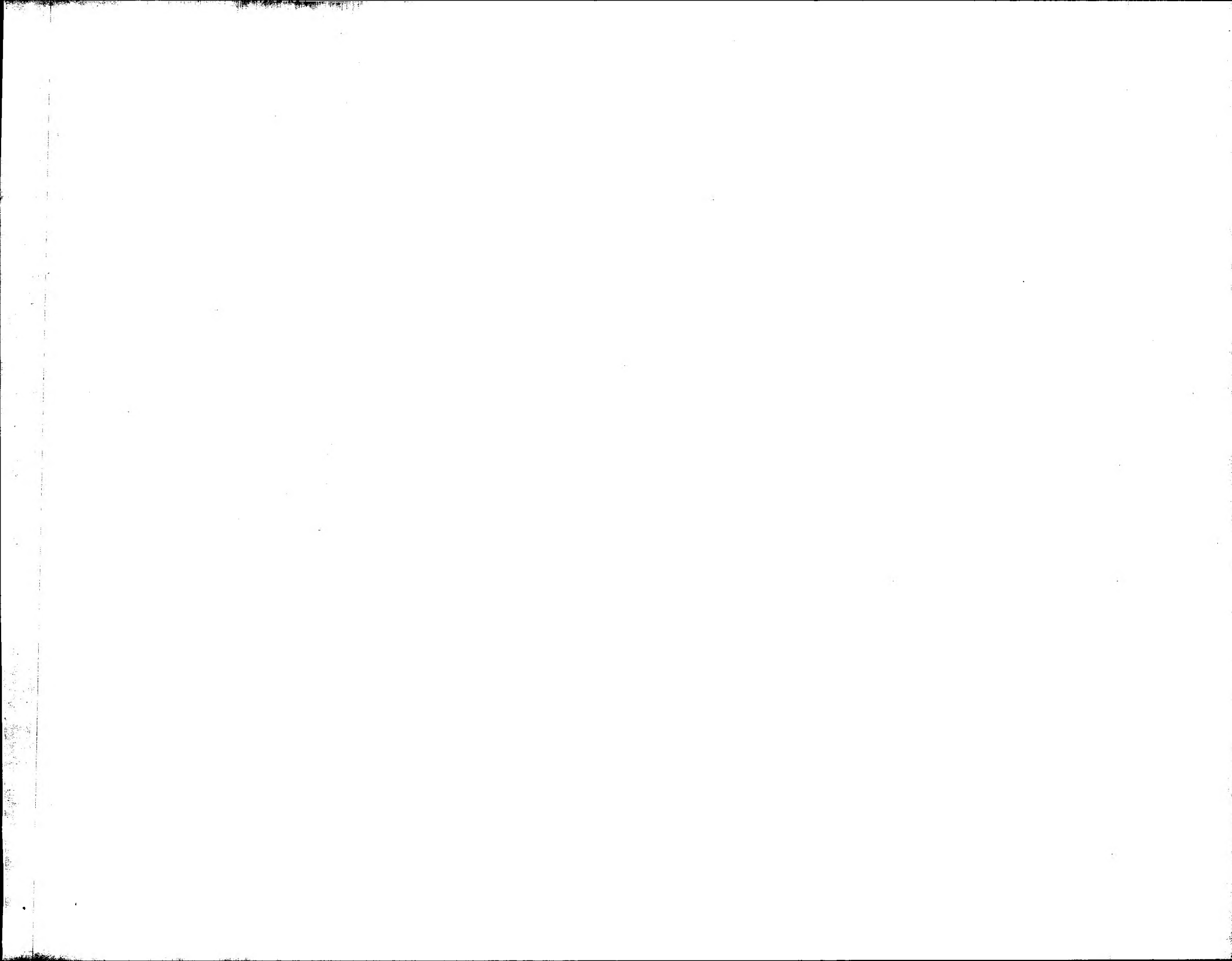
DETAIL C D7-2



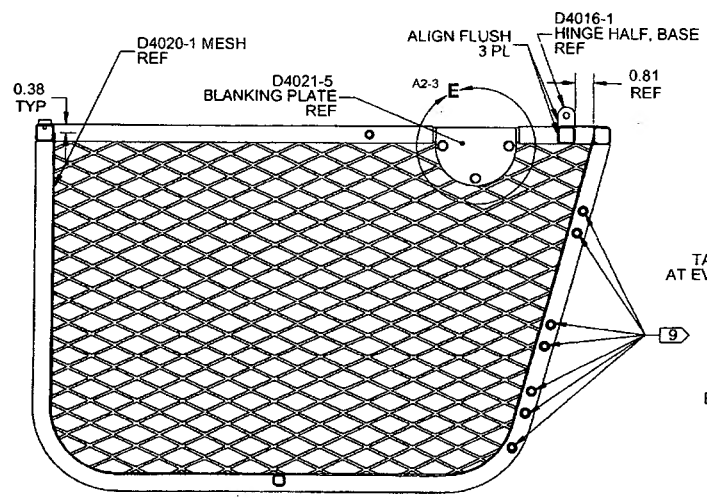
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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2012-07-12
40

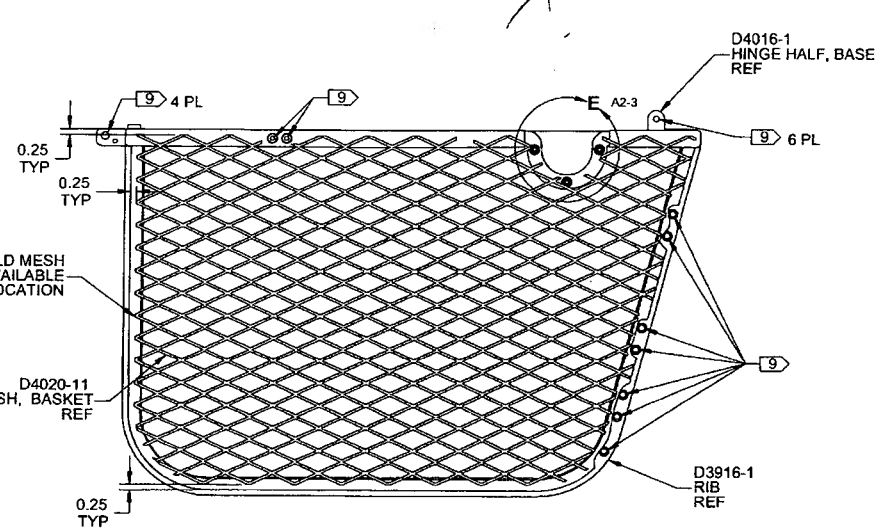
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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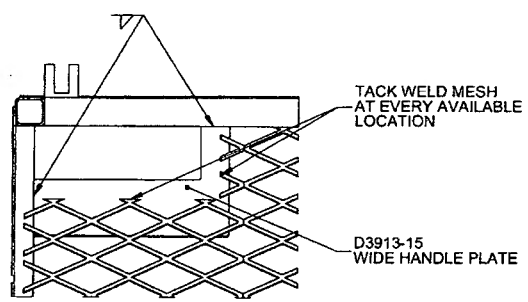
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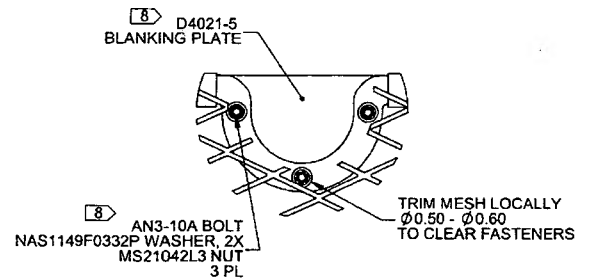
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES

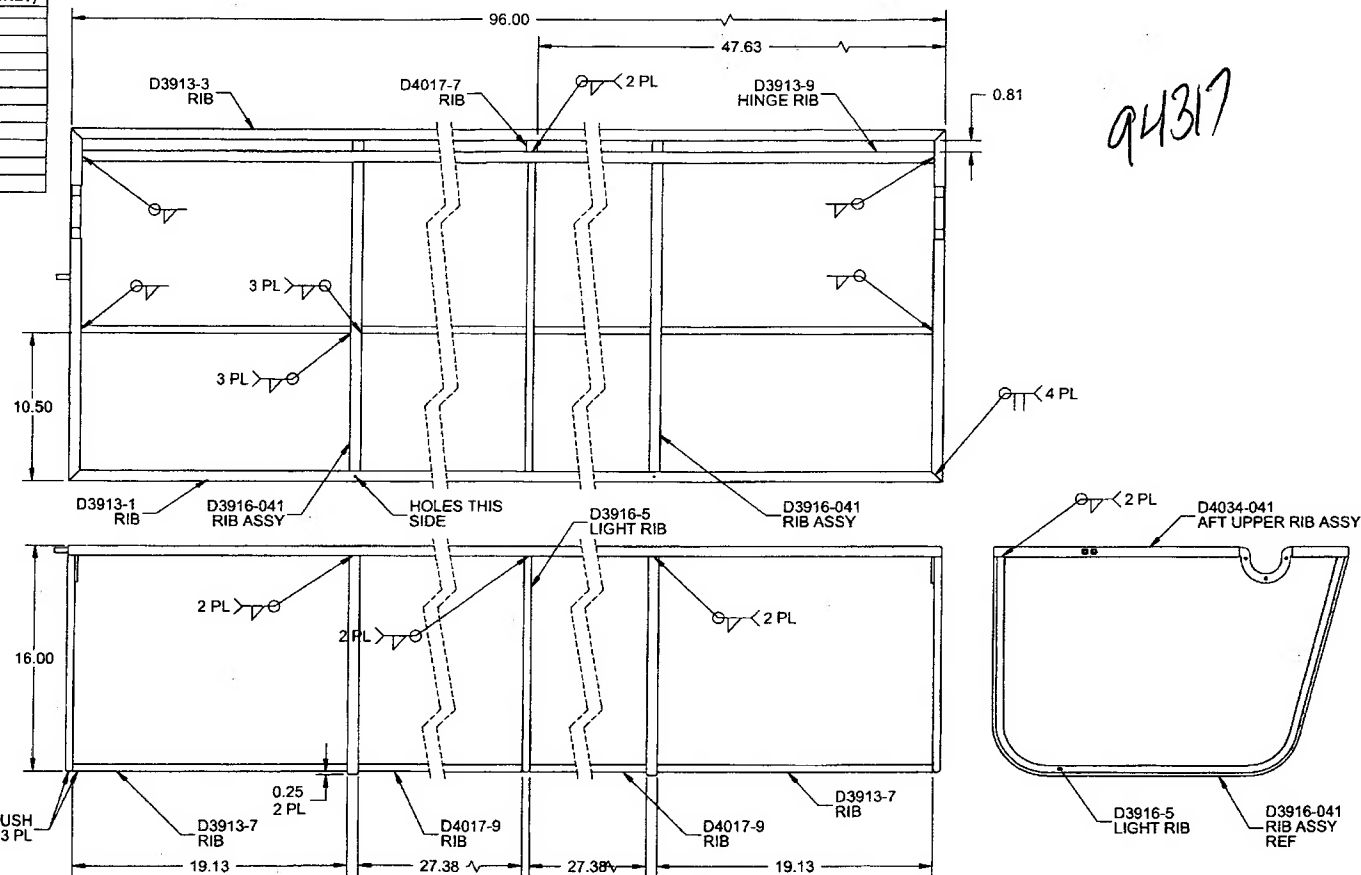


DETAIL E D2-3
D6-3

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DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3913	REV. B
CHECKED		SHEET 3 OF 6	
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET BASE ASSY (350) NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

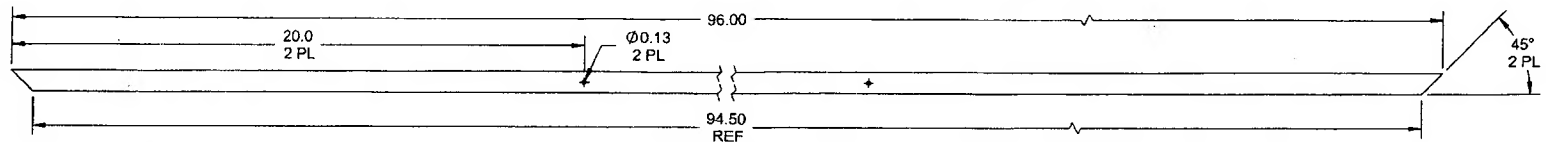
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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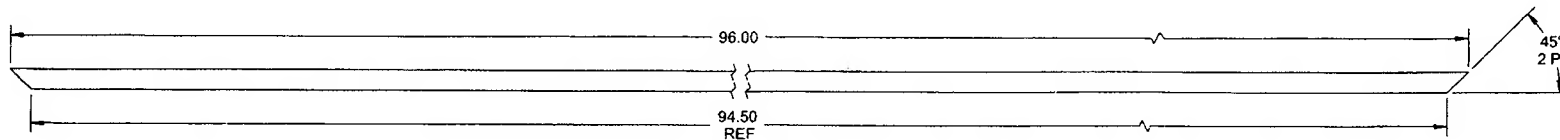
DESIGN	AKS	DART AEROSPACE LTD	REV. B
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	D3913
MFG. APPR.		TITLE	LONG BASKET BASE ASSY (350)
APPROVED		SCALE	NTS
DE APPR.			
DATE	12.06.15		

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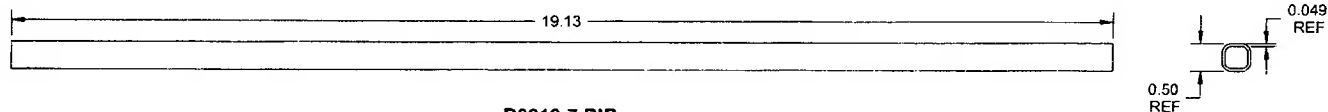
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D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

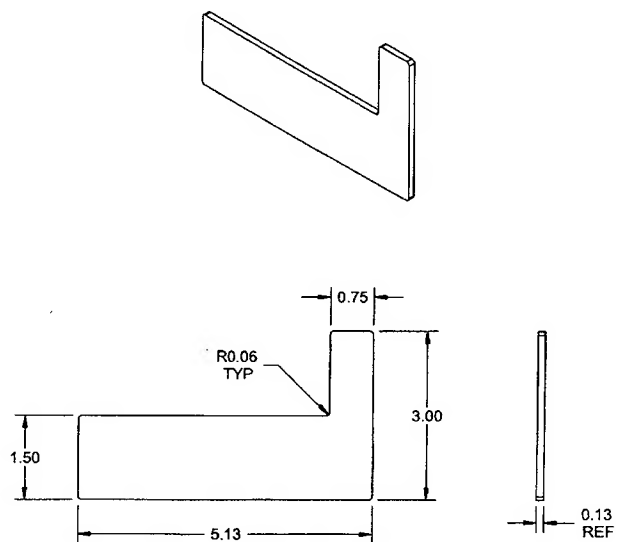
1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS	DRAWING NO.	REV. B
CHECKED	ALS	D3913	SHEET 5 OF 6
MFG. APPR.	ALS	TITLE	SCALE
APPROVED	ALS	LONG BASKET BASE ASSY (350)	NTS
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DATE	12.06.15		



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2012-07-12
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MFG. APPR.		D3913	SHEET 8 OF 8
APPROVED		TITLE	SCALE
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